

Job Procedure

Operating an Edging Machine

Tools/Equipment Required: Edging Machine

Materials Required: Ear Plugs
Glass Cleaner
Paper Towel

Steps:

1. Check water tank to make sure its full of water.
2. Set front arris wheel to thickness of glass to be edged on the dial with black arm set on zero and red on thickness.
3. Put ear plugs in or ear protection on.
4. Turn key to ON position.
5. Press green ON button for the motors and green ON button for the conveyor belt.
6. Put a test piece of glass the same thickness through first. Always add 1/16" to finished glass size when cutting to be edged.
7. Lines are indicated on machine where wheels are in contact with glass.
8. When flat grinding, set arris wheels to desired size by turning adjusting knobs clockwise for up, counter clockwise for down. (not over 4 of the gauges indicating arris).
9. When polishing (P-1) bring P-1 wheel up to the glass by turning adjusting know clockwise to 3 on P-1 gauge.
10. The same as step nine for P-2 (high polish) polish at the same time, setting gauge on 3.
11. When mitering always flat grind first.
12. To mitre, set switch to desired mitre (22.5, 0-60, 45) on control board, push lever up to bring motors to proper angle.
13. Check angle gauge by the P-2 motor for angle its set at.
14. Look on the chart that's taped to the right side of the control board for the number of turns for the degree of angle.
15. Turn the grinding wheels dial clockwise to the number of turns indicated on the chart and set arris accordingly.
16. Be sure to set grinding wheels and arris back to original position after mitering.
17. Bring motors back down with lever on control board.